

Date: Monday, 10/09/2007 9:19:21 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WINDOW ASSEMBLY
Job Number : 34472	
Estimate Number : 10304	
P.O. Number : N/A	Part Number : D3136043
This Issue : 10/09/2007 S.O. No. : N/A	Drawing Number : D3136 UNDER REVIEW
Prsht Rev. : NG	Project Number : N/A
First Issue : N/A	Drawing Revision : D
Previous Run : 33753	Material : P/A
Type : THERMOFORMING	Due Date : 21/09/2007
Written By : <u>[Signature]</u>	Qty: 20 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est Rev:A 04.02.04 New issue KJ/DS	
Est Rev.B 07.05.29 Thermoform in-house DL	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MACRLICS125	1/8" Polycast II Sheet
Comment: Qty.: 3.9000 sf(s)/Unit Total : 78.0000 sf(s) polycast II or plexiglass G .125"		
		M103735 (2) B# M104596 (18) JAN 07/09/10
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET		
		Dwg under review Pros B JAN 07/09/10 20
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
		JAN 07/09/10 20
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK		
		Sp Alorelia (420) counter
5.0	THERMOFORMING	THERMOFORMING MACHINE
Comment: 1-Thermoform as per Dwg D3136-3 and Folio FTA002 Dwg Rev. <u>D</u> Folio Rev. <u>B</u>		
2- Engrave Part # and Batch # , and affix labels		
		BB 07/09/13 (19) →

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: AD Date: 07/09/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/09/13	#50	Sheet Blistered. R.C. tried to form it with the paper wrong.	<i>[Signature]</i> 05/10/12	Scrap and destroy No Replace	07/09/14 <i>[Signature]</i>	En 07/09/14	<i>[Signature]</i> 05/10/12	En 07/09/14
07/09/14	#50	Two windows were scrapped on the wrong S.D. according to the Dwg. R.C. Hannon error	<i>[Signature]</i> 05/10/12	Re describe to the correct location on the Dwg.	07/09/14 <i>[Signature]</i>	En 07/09/14	<i>[Signature]</i> 05/10/12	En 07/09/14

NOTE: Date & initial all entries

Date: Monday, 10/09/2007 9:19:21 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WINDOW ASSEMBLY

Job Number: 34472

Part Number: D3136043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D31089

Decal



Comment: Qty.: 2.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick:

Qty Part# Description Batch

2 D3108-9 Decal

B-22608 X(38)

07.09.13 DL

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

07.09.14 DL

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/09/14 (419) counter

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/09/17 (19)

(19)

10.0

QC21

FINAL INSPECTION W/O RELEASE



Comment: FINAL INSPECTION W/O RELEASE

07/09/17

Job Completion



U 07.09.18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

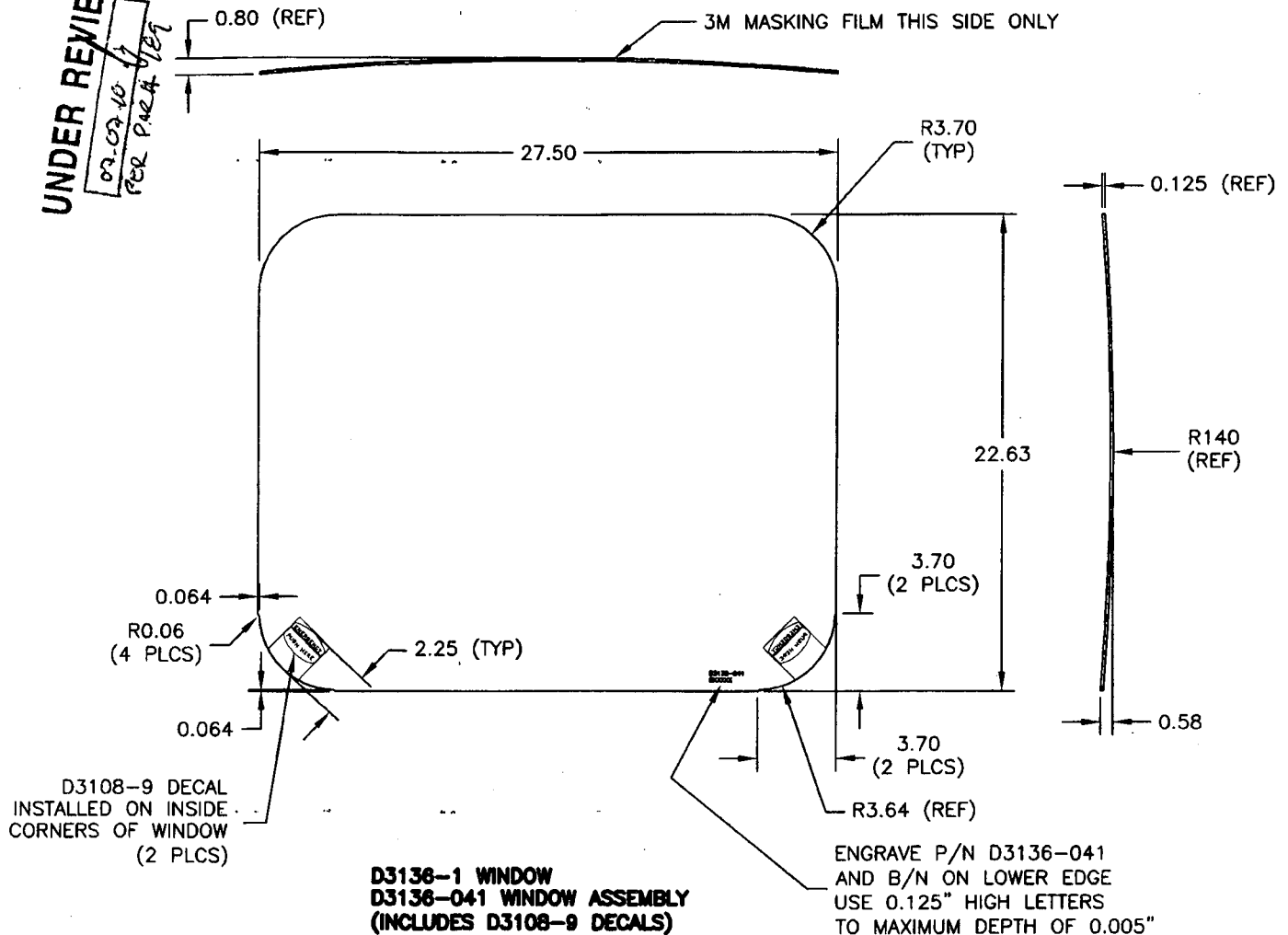
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**
05.12.01UNDER REVIEW
02.02.10
PER P424 VER

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3136	REV. D SHEET 1 OF 2
DATE 05.12.01		TITLE WINDOW ASSEMBLY	SCALE 1:8
A	02.04.18	NEW ISSUE	
B	04.01.21	ADDED D3136-3 AND D3136-043	
C	04.05.05	ADDED FORMING & ENGRAVING SPEC	
D	05.12.01	UPDATED MATERIAL NOTES	

**NOTES:**

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G
CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK
- 2) FORMING PROCESS: a) HEAT LARGER PIECE TO 250° F
b) DRAPE OVER D3136-T1 MOLD & CLAMP
c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS
d) TRIM PER TEMPLATE D3136-TT2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

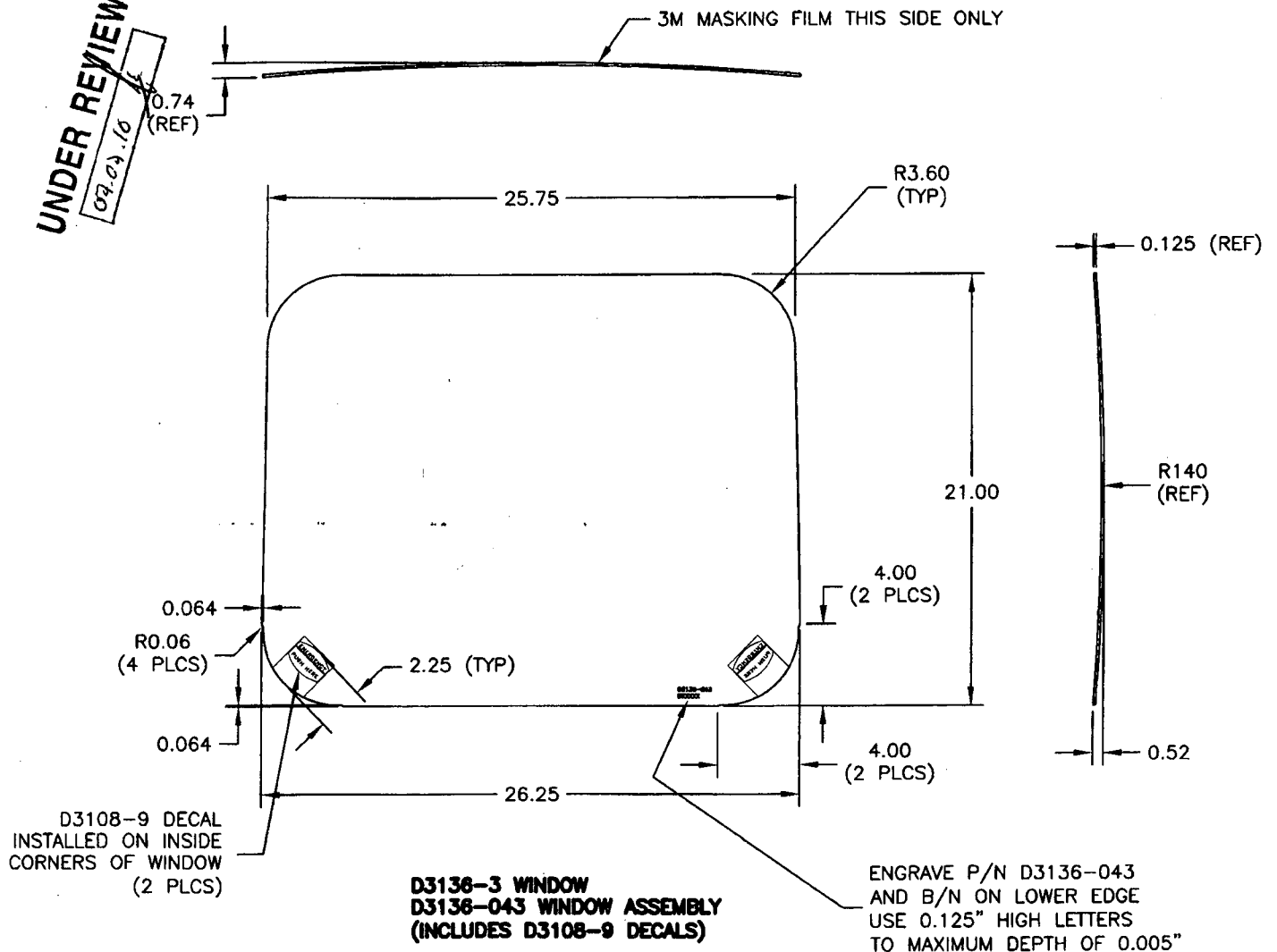
07.09.10
D

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DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3136	REV. D SHEET 2 OF 2
DATE 05.12.01		TITLE WINDOW ASSEMBLY	SCALE 1:8

RELEASED
05.12.01 *[Signature]***UNDER REVIEW**
07.03.10 *[Signature]***NOTES:**

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G
CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK
- 2) FORMING PROCESS: a) HEAT LARGER PIECE TO 250° F
b) DRAPE OVER D3136-T1 MOLD & CLAMP
c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS
d) TRIM PER TEMPLATE D3136-3T1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES



07.09.10 PC

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DART AEROSPACE LTD	Work Order:	34472
Description: Window Assembly	Part Number:	D3136043
Inspection Dwg: D3136 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article** ☐ **Prototype**

[illegible]

Measured by:	<i>SAD</i>	Audited by:	<i>SP</i>	Prototype Approval:	<i>MA</i>
Date:	<i>07/09/10</i>	Date:	<i>07/09/10</i>	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	